



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3307-00-03

Job Sheet 171172



Part No: RBE350A93-3307-00-03

Job Qty: 6 ea

Part Name: Washer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3307-00 Rev 2A IPP Rev A 18.01.24 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Machining-3		18/3/16
110	CNC Lathe	6 pcs		2/9/18	0.00	0.24	MORI SL-154 <i>Planing / Lathe</i>		18/3/19
120	QC	6 pcs		2/9/18	0.00	0.00	QC2 Machining-4		18/3/19
130	QC	6 pcs		2/9/18	0.00	0.00	QC8 Machining-4		18/03/27
150	Outsource	6 pcs		2/9/18	0.00	0.00	Outsource		
160	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging2		DAS
170	QC	6 pcs		2/9/18	0.00	0.00	QC6		38
180	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-1 <i>CA</i>		9-86
190	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		MAR 7 8 11/18 21 APR 0 6 2 18

Part Op 110 - 1-Machine as per DWG. FB 792 FOLIO REV: DWG REV: 2-Deburr

Descriptions: 150 - Issue P/O to Groupe Aitech; PO - Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 - Certificate of Conformity is required *N/A*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.000 <i>M304 R 1.000</i>	M1018R1.000	.2100 ft (.035 ea)	90-Start up Operation	<i>5052544</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.000	0	0	0

Part Specifications

Specifications could not be found.

915 945 / 645 815

Plex 1/29/18 4:09 PM Dart.lajeunesse.marie



Container No: S052551



Part: RBE350A93-3307-00-03

Job No: 171172

Serial No/Batch: S052551

Revision: 2A

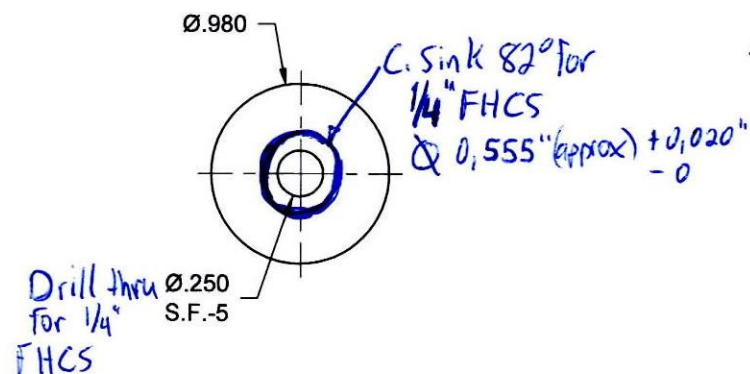
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/19/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D WASHER TO P/N -03 & S.F. TO 5, CH'D ALL THREAD TO HEX HEAD CAP SCREW P/N -05 & S.F. TO 3 PER D.W., DELETED -03 WELDMENT.	11/17/09	RJC	RW



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171172 MJS
18-01-29

(-03)
WASHER

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00-03	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS .XXX $\pm .005$.XX $\pm .01$.X $\pm .1$	APPROVED <i>D. Weil</i>
FRACTIONS $\pm 1/32$ ANGLES $\pm 5^\circ$	HEAT TREAT FINISH SPEC BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350/355
SCALE NTS	DATE 9/28/09 SHEET 3 of 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>171172</u> Part No. <u>RBE350A93-3307-00</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Description Work Order Deviation				Disposition																																																																											
As an alternative to expanding the end of the -05 Hex Head Cap Screw to secure the -03 Washer a countersunk screw can be used to secure the -03 Washer. Cut -05 Hex Head Cap Screw 2.63" long and tap 1/4"-20 hole 1.0" deep (on threaded end). Drill 0.25" hole through center of -03 Washer and CSK 0.55" x 82 deg, mfg from 303/304/316 SS, no black oxide required. Apply Loctite 262/263 to McMaster 91253A540 Screw or equivalent and assemble -03 and -05 together. (washer must rotate free),				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.				Completed By 																																																																							
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